

# Work Order ID 70097

Thursday, May 26, 2011 3:04:54 PM



Page 1

Item ID: DSK077

Accept



Setup Start



Revision ID:

Item Name: D2892-1 TURNING DETAIL

Stop



Start Date: 5/26/2011 Start Qty: 7.00



Cust Item ID:

Required Date: 6/15/2011 Req'd Qty: 7.00

Customer:

Reference:

Approvals:

Process Plan:

*[Signature]*

Date: 11-05-26

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
DSK077	Rev A								
100	MORI SEIKI CNC LATHE LARGE	0.00							
	Doosan	0.00	<i>RQ</i>	<i>11.6.1</i>		<i>7</i>			
Doosan Lathe	Memo Turn blank as per Folio FA082 check bore with DT8495								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
	QC	0.00	<i>RQ</i>	<i>11.6.1</i>		<i>7</i>			
Quality Control	Memo								
120	QC8- Inspect parts - second check	0.00							
	QC	0.00	<i>SA</i>	<i>11/6/11</i>		<i>7</i>			
Quality Control	Memo								

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 70097**

Thursday, May 26, 2011 3:04:54 PM



Page 2

Item ID: DSK077

Accept



Setup Start



Revision ID:

Stop



Item Name: D2892-1 TURNING DETAIL

Start Date: 5/26/2011 Start Qty: 7.00



Cust Item ID:

Required Date: 6/15/2011 Req'd Qty: 7.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  Packaging Packaging	Packaging  Memo Identify and Stock in Kanban <input type="checkbox"/> Location: <u>over</u>	0.00  0.00		11.2.1		7			
140  QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00  0.00							

11/6/2011  
ME  
11-05-01

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Thursday, May 26, 2011 3:05:01 PM

Page 1

Work Order ID: 70097

Parent Item: DSK077

Parent Item Name: D2892-1 TURNING DETAIL



Start Date: 5/26/2011

Required Date: 6/15/2011

Start Qty: 7.00

Required Qty: 7.00

Comments: IPP rev A. 08.03.13 new issue EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6104-003 		Manufactured	No				Each	21.0000		7			
Round Billet, 17-4										29	11	6	1

Location

Loc Qty

Loc Code

MAT043

21

60943  
66960  
68174

3

2

16

1  
6

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

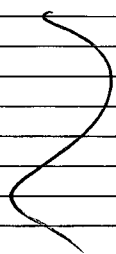
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	70097
<b>Description:</b> Turning Detail for D2892-1		<b>Part Number:</b>	DSK077
<b>Inspection Dwg:</b> DSK077	<b>Rev:</b> A	<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION DIMENSION SHEET



☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
Lathe Section								
A	2.524	2.529		2.529	2.529	2.529	2.529	2.529
B	3.702	3.722		3.714	3.714	3.714	3.714	3.714
C	2.814	2.834		2.824	2.824	2.824	2.824	2.824
D	0.718	0.738		.724	.724	.724	.724	.724
E	0.090	0.110		.102	.102	.102	.102	.102
F	2.714	2.734		2.724	2.724	2.724	2.724	2.724
G	2.029	2.049		2.039	2.039	2.039	2.039	2.039
H	3.214	3.234		3.221	3.221	3.221	3.221	3.221
I	0.913	0.933		.920	.920	.920	.920	.920
J	0.022	0.042		.032	.032	.032	.032	.032
K	0.090	0.110		.101	.101	.101	.101	.101
L								
M								
N								
O								
P								

Measured by:  Date: 11.6.1

Audited by:  Date: 11/6/11

Prototype Approval: \_\_\_\_\_ Date: \_\_\_\_\_

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM 	

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			


**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 70097
<b>Description:</b> Turning Detail for D2892-1		<b>Part Number:</b> DSK077
<b>Inspection Dwg:</b> DSK077 <b>Rev:</b> A		<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article      ☐ Prototype

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D	0.718	0.738		.724	.724	.724	.724	.724
E	0.090	0.110		.102	.102	.102	.102	.102
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K	0.090	0.110		.101	.101	.101	.101	.101
L								
M								
N								
O								
P								

<b>Measured by:</b> Zg	<b>Date:</b> 11.6.11
<b>Audited by:</b> [Signature]	<b>Date:</b> 11/6/11
<b>Prototype Approval:</b>	<b>Date:</b>

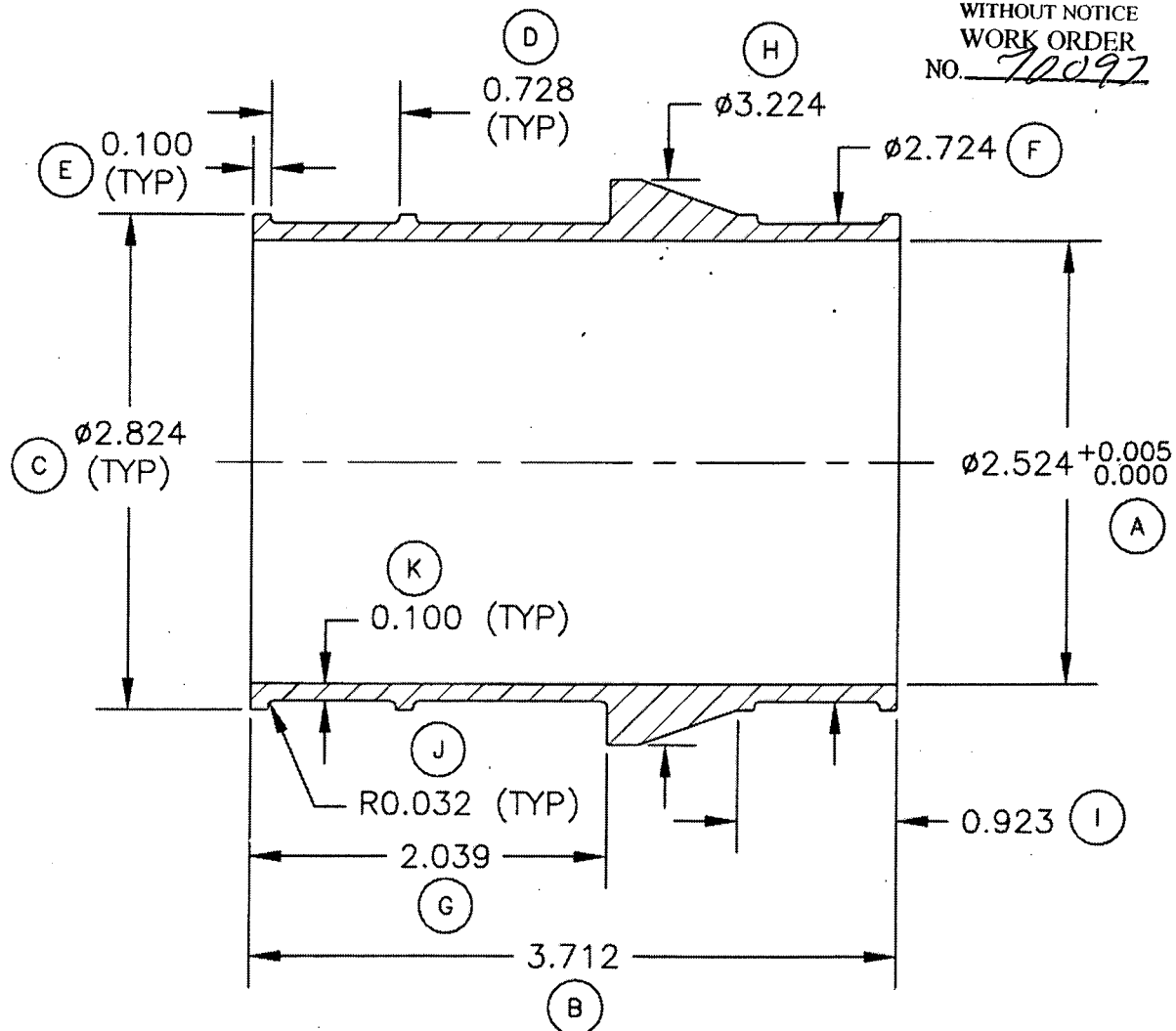
Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM [Signature]	[Signature]

**DART**

DESIGN TH	DRAWN BY TH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED TH	APPROVED TH	DRAWING NO. DSK 077	REV. A SHEET 1 OF 1
DATE 03.05.20		TITLE TURNING DETAIL FOR D2892-1	SCALE 1:1
A	03.05.20	NEW ISSUE	

RELEASED  
03.07.01

SHOP COPY  
RETURN TO  
ENGINEERING  
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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 70097



D2892-1 TURNING DETAIL

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W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
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